

140. The article as in claim 138, wherein the fabric has a warp yarn round packed cover factor of at least about 76%.

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CONT 141. The article as in claim 138, wherein the plurality of fill yarns and warp yarns includes a first yarn comprising fibers of the first type and second yarn comprising fibers of the type different from the first type.

142. The article as in claim 141, wherein the first yarn consists essentially of fibers of the first type and the second yarn consists essentially of fibers of the type different from the first type.

143. The article as in claim 138, wherein the plurality of fill yarns and warp yarns includes at least one yarn comprising at least a first fiber bundle and a second fiber bundle, the first fiber bundle comprising fibers of the first type and the second fiber bundle comprising fibers of the type different from the first type.

144. The article as in claim 143, wherein the plurality of fill yarns and warp yarns includes at least one yarn comprising at least a first fiber bundle and a second fiber bundle, the first fiber bundle consisting essentially of fibers of the first type and the second fiber bundle consisting essentially of fibers of the type different from the first type.

145. The article as in claim 143, wherein the first fiber bundle and the second fiber bundle are plied together to form the yarn with a secondary ply twist of at least about  $\frac{1}{4}$  that of a primary twist of the first fiber bundle and the second fiber bundle.

146. The article as in claim 145, wherein the first fiber bundle and the second fiber bundle are plied together to form the yarn with a secondary ply twist of at least about  $\frac{1}{2}$  that of a primary twist of the first fiber bundle and the second fiber bundle.

147. The article as in claim 138, wherein at least one of the fiber of the first type and the fiber of a type different from the first type is a fiber having a tensile breaking strength of at least about 10 g/Denier.

148. The article as in claim 147, wherein at least one of the fiber of the first type and the fiber of a type different from the first type is formed of a material selected from the group consisting of: para-aramids; liquid crystal polyesters; ultra-high molecular weight polyethylenes; and poly(p-phenylene-2,6-benzobisoxazole) (PBO).

149. The article as in claim 147, wherein each of the fibers of the first type and the fiber of a type different from the first type is a fiber having a tensile breaking strength of at least about 10 g/Denier.

150. The article as in claim 147, wherein the fiber of the first type is a fiber having a tensile breaking strength of at least about 10 g/Denier and fiber of a type different from the first type has a tensile breaking strength less than about 10 g/Denier.

151. The article as in claim 150, wherein the fiber of a type different from the first type is formed of a material selected from the group consisting of: polyamides; cellulosic materials; polyesters; acrylic polymers; and polyolefins.

152. The article as in claim 138, wherein the fabric includes therein at least one fiber bundle comprising at least one fiber of the first type and at least one fiber of a type different from the first type.

153. The article as in claim 152, wherein at least one of the fiber of the first type and the fiber of a type different from the first type is a fiber having a tensile breaking strength of at least about 10 g/Denier.

154. The article as in claim 153, wherein the fiber of the first type is a fiber having a tensile breaking strength of at least about 10 g/Denier and the fiber of type different from the first type has a tensile breaking strength less than about 10 g/Denier.

155. The article as in claim 154, wherein the fiber bundle comprises a plurality of fibers, at least 5% of which are fibers of the first type.

156. The article as in claim 154, wherein the fiber bundle comprises a plurality of fibers, at least 15% of which are fibers of the first type.

157. The article as in claim 154, wherein the fiber bundle comprises a plurality of fibers, at least 25% of which are fibers of the first type.

158. The article as in claim 154, wherein the fiber bundle comprises a plurality of fibers, at least 50% of which are fibers of the first type.

159. The article as in claim 154, wherein the fiber bundle comprises a plurality of fibers, at least 65% of which are fibers of the first type.

160. The article as in claim 154, wherein the fiber bundle comprises a plurality of fibers, at least 75% of which are fibers of the first type.

161. The article as in claim 154, wherein the fiber bundle comprises a plurality of fibers, at least 85% of which are fibers of the first type.

162. The article as in claim 154, wherein the fiber of the first type has a weight per unit length greater than that of the fiber of a type different from the first type.

163. The article as in claim 152, wherein each of the fiber of the first type and the fiber of a type different from the first type is a fiber having a tensile breaking strength of at least about 10 g/Denier.

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164. The article as in claim 152, wherein any given cross-section of the fiber bundle along its length includes therein between about 60 and about 100 fibers.

165. The article as in claim 152, wherein the fiber bundle is formed of a plurality of spun staple fibers each having a length per unit weight exceeding about 50 Cotton Count and a weight per unit length less than about 106 Denier.

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~~166. The article as in claim 165, wherein the fiber bundle is characterized by a primary twist multiplier of at least about 2.7 to at least about 5, and preferably at least about 4.~~

167. An article of apparel formed, at least in part, of the article as in claim 138.

168. The article of apparel as in claim 167, wherein the article of apparel is selected from the group consisting of: gloves; aprons; chaps; pants; boots; gators; shirts; jackets; coats; socks; shoes; undergarments; vests; waders; hats; protective suits; and gauntlets.

169. A method comprising the step of:  
weaving together a plurality of fill yarns and warp yarns into a woven fabric having a fill cover factor of at least about 75%, a warp yarn cover factor of at least about 100%, and including therein at least one fiber of a first type and at least one fiber of a type different from the first type.

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170. An article comprising:  
a fiber bundle formed of a plurality of fibers including at least one fiber of a first type having a tensile breaking strength of at least about 10 g/Denier, the fiber bundle having a length per unit weight exceeding about 50 Cotton Count and a weight per unit length less than about 106 Denier.

171. The article as in claim 170, wherein the fiber of the first type is formed of a material selected from the group consisting of: para-aramids, liquid crystal polyesters; ultra-high molecular weight polyethylenes; and poly(p-phenylene-2,6-benzobisoxazole) (PBO).

172. The article as in claim 170, wherein the fiber bundle is formed of a plurality of fibers including at least one fiber of a first type having a tensile breaking strength of at least about 10g/Denier and at least one fiber of a second type having a tensile breaking strength of at least about 10g/Denier.

173. The article as in claim 170, wherein the fiber bundle is formed of a plurality of fibers including at least one fiber of a first type having a tensile breaking strength of at least about 10g/Denier and at least one fiber of a second type having a tensile breaking strength less than about 10 g/Denier.

174. The article as in claim 173, wherein the fiber of the second type is formed of a material selected from the group consisting of: polyamides; cellulosic materials; polyesters; acrylic polymers; and polyolefins.

175. The article as in claim 173, wherein the fiber of the second type has a tensile breaking strength less than about 8 g/Denier, preferably 3-8 g/Denier.

176. The article as in claim 173, wherein the weight per unit length of the fiber of the second type is less than the weight per unit length of the fiber of the first type.

177. The article as in claim 173, wherein the weight per unit length of the fiber of the first type does not exceed about 5 Denier per fiber.

178. The article as in claim 177, wherein the weight per unit length of the fiber of the first type does not exceed about 2.5 Denier per fiber.

179. The article as in claim 178, wherein the weight per unit length of the fiber of the first type does not exceed about 1.5 Denier per fiber.

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180. The article as in claim 179, wherein the weight per unit length of the fiber of the first type does not exceed about 1 Denier per fiber.

181. The article as in claim 180, wherein the weight per unit length of the fiber of the first type does not exceed about 0.5 Denier per fiber.

182. The article as in claim 173, wherein the weight per unit length of the fiber of the second type does not exceed about 1.2 Denier per fiber.

183. The article as in claim 182, wherein the weight per unit length of the fiber of the second type does not exceed about 0.8 Denier per fiber.

184. The article as in claim 183, wherein the weight per unit length of the fiber of the second type does not exceed about 0.5 Denier per fiber.

185. The article as in claim 184, wherein the weight per unit length of the fiber of the second type does not exceed about 0.25 Denier per fiber.

186. The article as in claim 185, wherein the weight per unit length of the fiber of the second type does not exceed about 0.1 Denier per fiber.

187. The article as in claim 173, wherein the fiber bundle is formed of plurality of fibers at least 5% of which are fibers of the first type.

188. The article as in claim 170, wherein the fiber bundle has a length per unit weight exceeding about 60 Cotton Count and a weight per unit length less than about 89 Denier.

189. The article as in claim 188, wherein the fiber bundle has a length per unit weight exceeding about 70 Cotton Count and a weight per unit length less than about 76 Denier.

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190. The article as in claim 189, wherein the fiber bundle has a length per unit weight exceeding about 80 Cotton Count and a weight per unit length less than about 66 Denier.

191. The article as in claim 170, wherein the fiber bundle comprises a plurality of spun staple fibers.

192. The article as in claim 191, wherein the fiber bundle is formed by a Cotton System spinning process and the length of the staple fibers does not exceed about 2 inches.

193. The article as in claim 191, wherein the fiber bundle is formed by a Worsted System spinning process and the length of the staple fibers exceeds about 2 inches.

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194. The article as in claim 191, wherein the fiber bundle has a primary twist multiplier of at least about 2.7 to at least about 5, and preferably at least about 4.

195. A yarn comprising the fiber bundle as recited in claim 170.

196. A fabric comprising the yarn as recited in claim 195.

197. An article of apparel formed, at least in part, from the fabric as recited in claim 196.

198. The article of apparel as in claim 197, wherein the article of apparel is selected from the group consisting of: gloves; aprons; chaps; pants; boots; gators; shirts; jackets; coats; socks; shoes; undergarments; vests; waders; hats; protective suits; and gauntlets.

199. A method comprising the step of:

forming a fiber bundle having a weight per unit length of less than about 50 Cotton Count or less than about 105 Denier from a plurality of fibers including at least one high tenacity fiber having a tensile breaking strength of at least about 10 g/Denier.

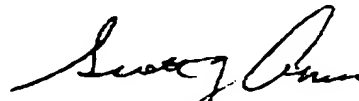
200. The method as in claim 199, wherein the fiber bundle is formed by spinning together a plurality of staple fibers having a length not exceeding about 2 inches utilizing Cotton System spinning.

201. The method as in claim 199, wherein the fiber bundle is formed by spinning together a plurality of staple fibers having a length not exceeding about 2 inches utilizing Worsted System spinning.

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Applicant believes the above amendments and remarks to place this application in condition for prosecution. No new matter is added. Applicant requests speedy consideration, and further requests that Examiner contact its attorney by telephone, facsimile, or email for quickest resolution, if there are any remaining issues.

Respectfully submitted,



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